IN THE CLAIMS:

Amend the claims as follows:

Claim 1. (Previously Amended): A bent work used as a bearing-receiving unit for construction machinery and manufactured by a method comprising the steps of:

preparing a belt-shaped thick steel material having an L-shaped cross-section and having two elongated sides and two ends; and

forming a cylinder by bending the belt shaped thick steel material by means of a center roller, a pair of bending rollers for bending the belt-shaped thick steel material, transferred along the center roller, which is disposed opposing the center roller at one side of the center roller, and a pressing roller for pressing the belt-shaped thick steel material, which is disposed opposing the center roller at one side of the center roller and positioned between the pair of the bending rollers,

so that the ends of the belt-shaped thick steel material abut each other.

Claim 2. (Canceled):

Claim 3. (Currently Amended): A bending method comprising the steps of:

providing a belt-shaped thick steel material having one of an L-shaped cross-section

and a U-shaped cross-section and having two elongated sides and two ends; and

forming the material into a cylinder so that the ends of the belt-shaped thick steel material abut each other by using a center roller to be driven to rotate which is positioned and fixed in a predetermined position, and a pair of bending rollers to be driven to rotate which is disposed opposing the center roller at one side of the center roller, movable toward and away from the center roller, and a pressing roller for pressing the belt-shaped thick steel material, transferred along the center roller, which is disposed opposing the center roller at one side of the center roller and positioned between the pair of bending rollers, the belt-shaped thick steel material ~~having one of an L-shaped cross-section and a U-shaped cross-section~~ being bent by being transferred between the (a) center roller and (b) the pair of bending rollers and the pressing roller, the bent work thereby obtained being used as a bearing receiving unit for construction machinery.

Claim 4. (Currently Amended): A bending device for bending a belt-shaped thick steel material having two elongated sides and two ends to form a cylinder where the ends of the belt-shaped thick steel material abut each other, the bent work thereby obtained being used as a bearing receiving unit for construction machinery, the bending device comprising:

a center roller to be driven to rotate positioned and fixed in a predetermined position;

and

a pair of bending rollers to be driven to rotate disposed opposing the center roller at one side of the center roller, movable toward and away from the center roller, and

a pressing roller rotatably disposed opposing the center roller at one side of the center roller, movable toward and away from the center roller, the belt-shaped thick steel material being bent by being transferred between (a) the center roller and (b) the pair of bending rollers and the pressing roller,

wherein the center roller is provided with an annular recess formed therein around the center roller, the pair of bending rollers are respectively provided with annular convex portions formed thereon around the bending rollers, the convex portions to be inserted in the annular recess of the center roller at a predetermined position of the annular recess of the center roller, and the belt-shaped thick steel material having one of an L-shaped cross-section and a U-shaped cross-section is transferred between (a) the center roller and (b) the pair of bending rollers and the pressing roller in a manner such that a concave portion of the belt-shaped thick steel member having one of an L-shaped cross-section and a U-shaped cross-section faces toward the outside at the annular recess of the center roller and the convex portions of the pair of bending rollers and a periphery of the pressing roller are positioned in the concave portion of the belt-shaped thick steel material ~~having one of an L-shaped cross-section and a U-shaped cross-section~~.

Claim 5 (Canceled):